

**REPLACEMENT ABSTRACT**

ABSTRACT OF THE INVENTION

A toolholder unit for sheet metal bending brakes, comprising a bar to be associated with a fixed or movable part of the brake, and provided with at least one recess forming with a jaw associated therewith a groove to receive the shank of the tool, there being provided elastic means to maintain said jaw spaced from said recess and from the shank contained therein, and locking means to clamp said jaw against said shank, said locking means comprising: at least one slider axially slidable within a seat facing that side of the bar facing the jaw; at least one appendix projecting from said slider beyond that side of the bar facing the jaw; at least one cavity provided in the bar, or in a part rigid with it, to receive said appendix; and means of variable profile to cause said slider to undergo controlled translations relative to said bar .